

July-03-12 1:26:40 PM

**\*86516\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*10\***

**Cust Item ID:**

**\*10\***

**Customer:**

**Reference:**

### Process Plan:

**Date:**

**Tooling:**

**Date:**

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):**

Date:

Stop \*NR2\*

**Insp.  
Stamp**

Rev D

100

0.00

**\*100\***

## FLOW WATER JET

0.00

### Waterjet

## Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3295 Dwg Rev: 1 Prog Rev: 1 2-  
Remove plastic and wrap in saran wrap.2-Deburr if necessary

Lexen .125

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

## Memo

0.00

### Quality Control





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**Item ID:** D3295-041

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

Stop **\*NS2\***

**Item Name:** Floor Window

**Start Date:** 7/03/12      **Start Qty:** 10.00

\*10\*

**Cust Item ID:**

**Required Date:** 7/04/12      **Req'd Qty:** 10.00

\*10\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

### Operation Description

## Set Up/ Run Hours

## Tool ID

**Tool #****Plan  
Code**

**Accept**  
**Qty**

Reject  
QtyReject  
Number**Insp.  
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

### Quality Control

12-07-4

# Picklist Print

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Work Order ID: 86516

Parent Item: D3295-041

Parent Item Name: Floor Window

Start Date: 7/03/12

Required Date: 7/04/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM  
IPP Rev:D Added DT8822 07-03-20 JLM  
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1 Dart Logo label		Manufactured	No			100	Each	0.0000	0	0			
MLEXS.125-9034-01 1/8" 9034 Lexan Sheet		Purchased	No			140	sf	201.9000	1.24	13.052632			Jm 12-7-3
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT019		201.9							
				117273		106.9							
				119591		95							
								119591					

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 810516
<b>Description:</b> Window		<b>Part Number:</b> D3295
<b>Inspection Dwg:</b> D3295	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	0.156"	✓		V	mmoi
17.13	+/-0.030	17.130"	✓		MT	mmoi
10.43	+/-0.030	10.432"	✓		V	Producer
14.35	+/-0.030	14.35"	✓		MT	mmoi
8.98	+/-0.030	8.985"	✓		V	Producer
0.625	+/-0.010	0.633"	✓		V	mmoi
7.109	+/-0.010	7.113"	✓		V	"
15.845	+/-0.010	15.845"	✓		MT	mmoi
2.308	+/-0.010	2.311"	✓		V	mmoi
5.420	+/-0.010	5.429"	✓		V	"
9.402	+/-0.010	9.410"	✓		V	Producer
1.312	+/-0.010	1.313"	✓		V	mmoi
6.260	+/-0.010	6.269"	✓		V	"
12.520	+/-0.010	12.520"	✓		MT	
0.313	+/-0.010	0.320"	✓		V	mmoi
3.750	+/-0.010	3.756"	✓		V	"
8.150	+/-0.010	8.154"	✓		V	"
9.006	+/-0.010	9.013"	✓		V	Producer
0.125	+/-0.010	0.116"	✓		V	mmoi

<b>Measured by:</b> SM	<b>Audited by:</b> E	<b>Prototype Approval:</b> N/A
<b>Date:</b> 12-7-3	<b>Date:</b> 12/7/04	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	



